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C3-4-2
Job Sheet 181340



Part No: C3-4-2

Job Qty: 5 ea

Part Name: Trunnion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/25/18

Job Tracking No:

Due Date: 7/26/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG C3-4-2 Rev 18 IPP Rev A 18.03.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/26/18	7/26/18	0.00	0.00	Start Up Machining-4		DAS 39
120	CNC Lathe	5 pcs	7/26/18	7/26/18	1.50	0.63	MORI SL-154		18/7/22 9-80
130	QC	5 pcs	7/26/18	7/26/18	0.00	0.00	QC2 Machining-5		18-07-30
160	QC	5 pcs	7/26/18	7/26/18	0.00	0.00	QC8 Machining-5		SB
200	Packaging	5 pcs	7/26/18	7/26/18	0.00	0.00	Packaging3-2		DAS 21
210	QC21-SA	5 Ea	7/26/18	7/26/18	0.00	0.00	QC21		JUL 31 2018

Part Op Descriptions: 120 - 1-Machine as per folio FB956 FOLIO REV: _____ DWG REV: _____ 2-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.000	AISI 4140 Quenched & Tempered Steel Round Bar 1.000" Dia.	.7750 ft (.155 ea)	90-Start up Operation	5093068

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.000	1	35	0

Part Specifications

Specifications could not be found.



Container No: S096836



Part: C3-4-2

Job No: 181340

Serial No/Batch: S096836

Revision: 6

Inspector:

Exp Date:

Instructions:

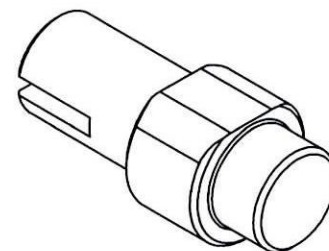
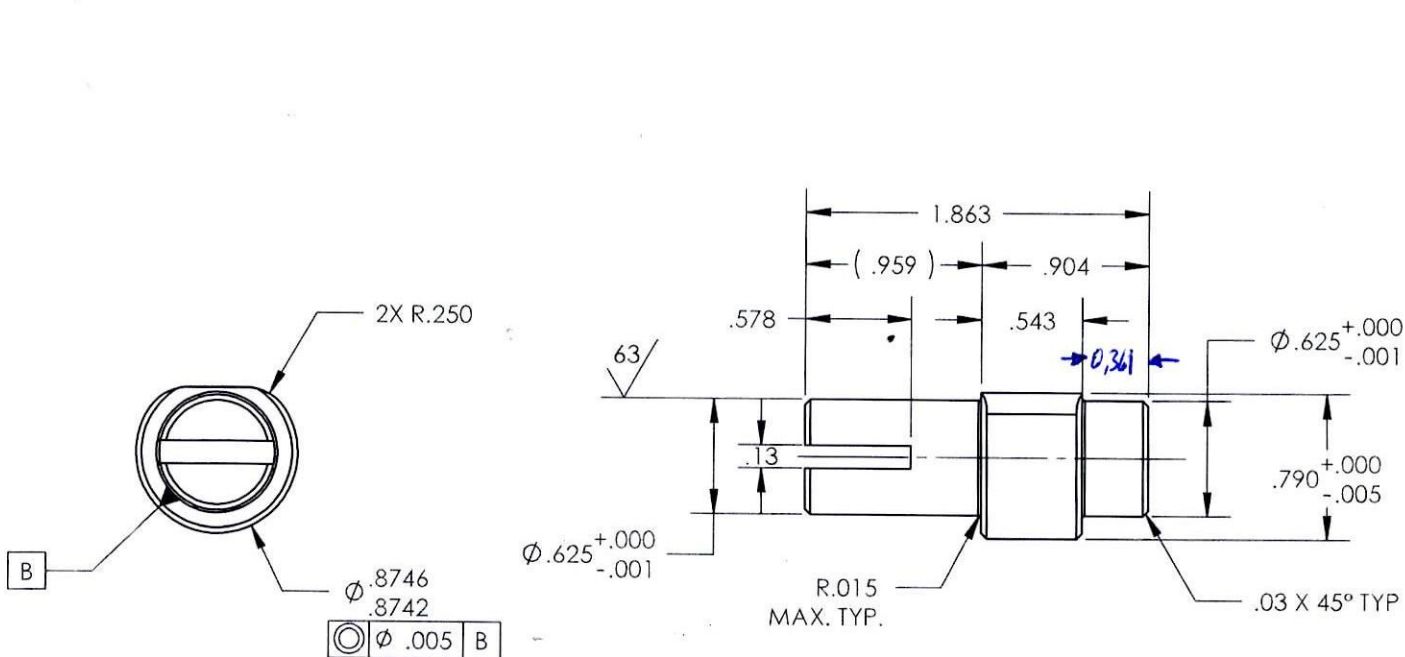
Date: 07/27/18

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Plex 7/25/18 3:52 PM dart.white.jesse

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		CH'D DIMENSIONS FROM R.4375 +.0000 -.0005, TO $\phi .8746 - .8742$, CH'D TOLERANCE FOR $\phi .790 + / - .005$ TO $\phi .790 +.000 / -.005$	8/8/2012	RJC	SE
8	14-0106	ADDED BAG & LABEL NOTE	8/6/2014	DJN	RW
10	15-0198	C3-4-2 CORRECTED GD&T.	8/27/2015	DPD	JAG



NOTES:

1. NICKEL PLATE AFTER PART HAS BEEN ASSEMBLED WITH LOAD BEAM C3-4-4.
2. BAG & LABEL WITH BATCH NUMBER.

To fit hook
 ϕ must be
 0.873
 0.8722

MATCH MACHINE WITH
 LOAD BEAM
 Mfg JULY 31/18

(C3-4-2) PARTS WERE MACHINE
 TRUNNION (PICK TO PRECISION)

DART AEROSPACE	
TITLE C3 LOAD BEAM ASSEMBLIES	
DWG NO. C3-4-4A / C3-4-4KA	REV 10
MAT'L 4140 Q&T / 4142 Q&T	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm$.005 FRACTIONS $\pm$ 1/8	HEAT TREAT
.XX $\pm$.01 ANGLES $\pm$ 5°	FINISH
.X $\pm$.1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 10/31/2001
SHEET 4 OF 6	